

Work Order ID 106612

September-10-13 11:24:29 AM

*ASAP*

\*106612\*

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Item ID: D4695-6 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Channel  
 Start Date: 9/10/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 9/11/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4695	B								

100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4695-5F as per Dwg								
	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr if necessary								
									<i>4 0 JmB-09-10</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									<i>4 0 JmB-09-10</i>
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									
									<i>4 0 JmB-09-10</i>

DAS  
27  
9-89  
139-10

# Work Order ID 106612

\*106612\*

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September-10-13 11:24:29 AM

Item ID: D4695-6 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Channel  
 Start Date: 9/10/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 9/11/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00				4			Sp 12/09/14
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5M 13911		4			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	76	13-9-11	

# Work Order ID 106612

September-10-13 11:24:29 AM

**\*106612\***

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Item ID: D4695-6

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Channel

Start Date: 9/10/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*180*</b>									
QC	Memo	0.00				4x			13/09/12
Quality Control									
190	Identify as per dwg & Stock Location: <u>C-A</u>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00				4x			13/09/12
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							13/9/13
Quality Control									

13-09-12

# Picklist Print

September-10-13 11:24:28 AM

Page 1

Work Order ID: 106612

Parent Item: D4695-6

Parent Item Name: Channel

Start Date: 9/10/13

Required Date: 9/11/13

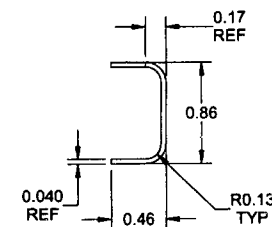
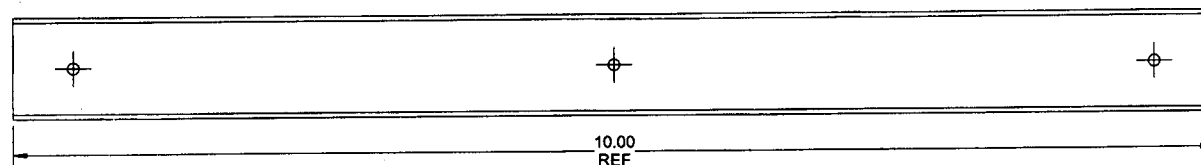
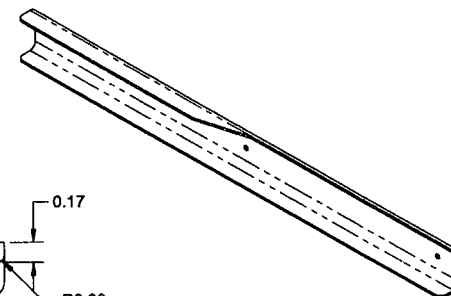
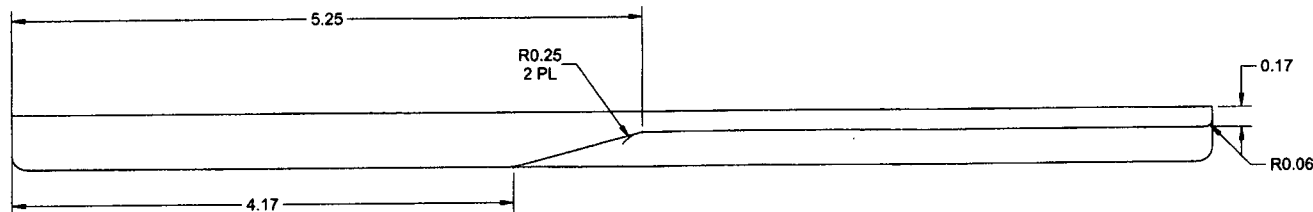
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.08.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	272.5670	0.109	0.4589174 1.0			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT021		272.567							
				m126350		272.567		126350					

JMB-09-10



# **D4695-5 CHANNEL**

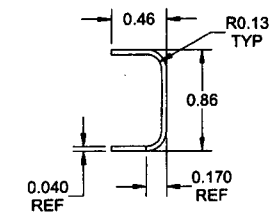
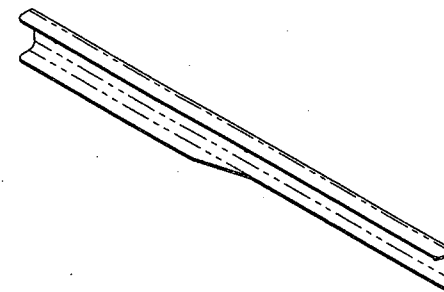
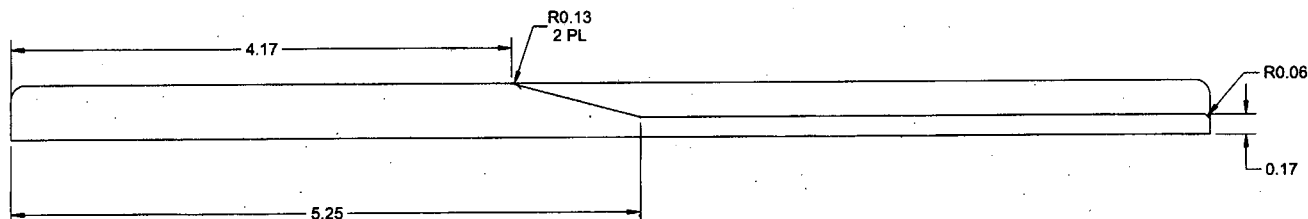
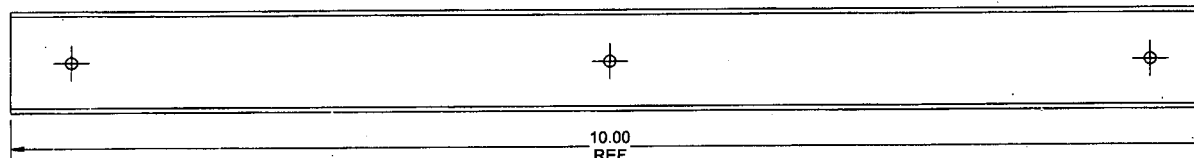
*see 10 10/10/12*

**RELEASED**  
2013-04-02

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4695-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	<b>D4695</b>	SHEET 10 OF 12
APPROVED	<i>14</i>	TITLE	SCALE
DE APPR.	<i>14</i>	<b>CHANNEL ASSEMBLY</b>	NTS
DATE	13.03.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

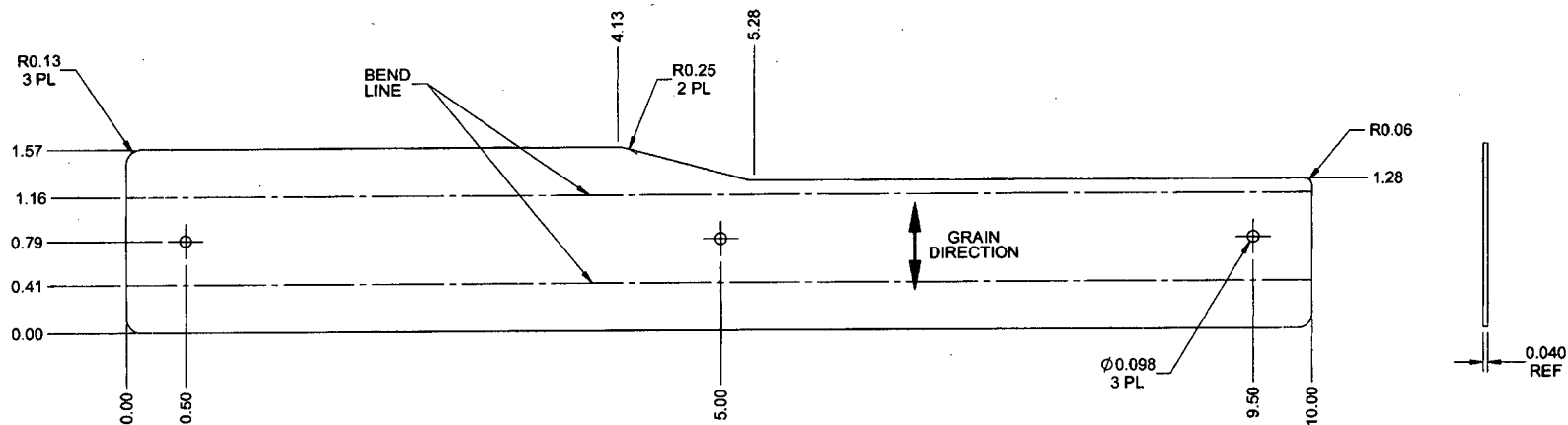


**D4695-6 CHANNEL**

**RELEASED**  
2013-04-02

- NOTES:**
- 1) MATERIAL: MAKE FROM D4695-5F FLAT PATTERN
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.06 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	<b>D4695</b>	SHEET 11 OF 12
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	<b>CHANNEL ASSEMBLY</b>	NTS
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# **D4695-5F FLAT PATTERN CHANNEL**



RELEASED  
2013-04-02

## **NOTES:**

- 1) MATERIAL: 8061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	ST	<b>D4695</b>	SHEET 12 OF 12
APPROVED	14	TITLE	SCALE
DE APPR.	14	<b>CHANNEL ASSEMBLY</b>	NTS
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